

Work Order ID 85110

Friday, June 01, 2012 4:04:53 PM

85110

Page 1

Item ID: PB67-43001-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MUF*Date: *12-06-04* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-11

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

3- grind weld flush in area of PB67-43001-249 only

4- install helicol insert as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

12-06-18
*FF 12-06-18**12-06-19*

W/O:		WORK ORDER CHANGES					
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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET START TIME:
10:30 OVEN TEMPERATURE: 320°F FINISH TIME: 11:20

1 7/6 12-6-19

1X Ø

m/f
12/06/20

M18144

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Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

DICK Kit

1x 4 11/10/20

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support2- assemble as per dwg

1x SP 12-6-21

1 0 Ae
12.06.25

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 12.06.25

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Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

6/6/2012

12/6/26

ME
12.06-25

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Picklist Print

Friday, June 01, 2012 4:04:53 PM

Page 1

Work Order ID: 85110

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.09.27 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67		Manufactured	No	B 85187	(R)		Each	0.0000		1		6/12/06/18	
PB67-43001-67													
PB67-43001-247		Manufactured	No			100	Each	1.0000	1	1		6/12/06/18	
Inner Tube													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		1							
				44985		1							
PB67-43001-249		Manufactured	No			100	Each	7.0000	1	1		6/12/06/18	
Inner Tube Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		7							
				52480		7							
PB67-43001-253		Manufactured	No	B 85185	(1)	100	Each	0.0000	1	1		6/12/06/18	
Gusset													
PB67-43001-254		Manufactured	No			100	Each	20.0000	1	1		6/12/06/18	
Gusset													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		20							
				52481		20							
MS124780		Purchased	No			180	Each	86.0000	1	1		6/12/06/18	
HELICAL INSERT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		86							
				111064		86							

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 85110

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

180

Each

126.0000

8

Screw

Location

Loc Qty

Loc Code

GA

100

120449

100

ST291

26

120120

26

NAS1149D0316J

AWGOTDIAL

Purchased

No

180

Each

0.0000

8

Washer

NAS1149D0363J

Purchased

No

180

Each

2,183.0000

8

Washer

Location

Loc Qty

Loc Code

ST298

2183

117601

61

118077

1

118612

18

119537

33

120142

13

120308

17

120644

86

121243

494

121524

1460

PB67-43001-69

Manufactured

No

180

Each

3.0000

1

90 Degree Cover Plate

Location

Loc Qty

Loc Code

ST437A

3

52433

3

PB67-43001-83

Manufactured

No

180

Each

11.0000

1

PB67-43001-83

Location

Loc Qty

Loc Code

ST444

11

53240

11

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Shop Packet Print

Page 2

m122027 SP

m19600 SP

SP

SP 12-6-28

1X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

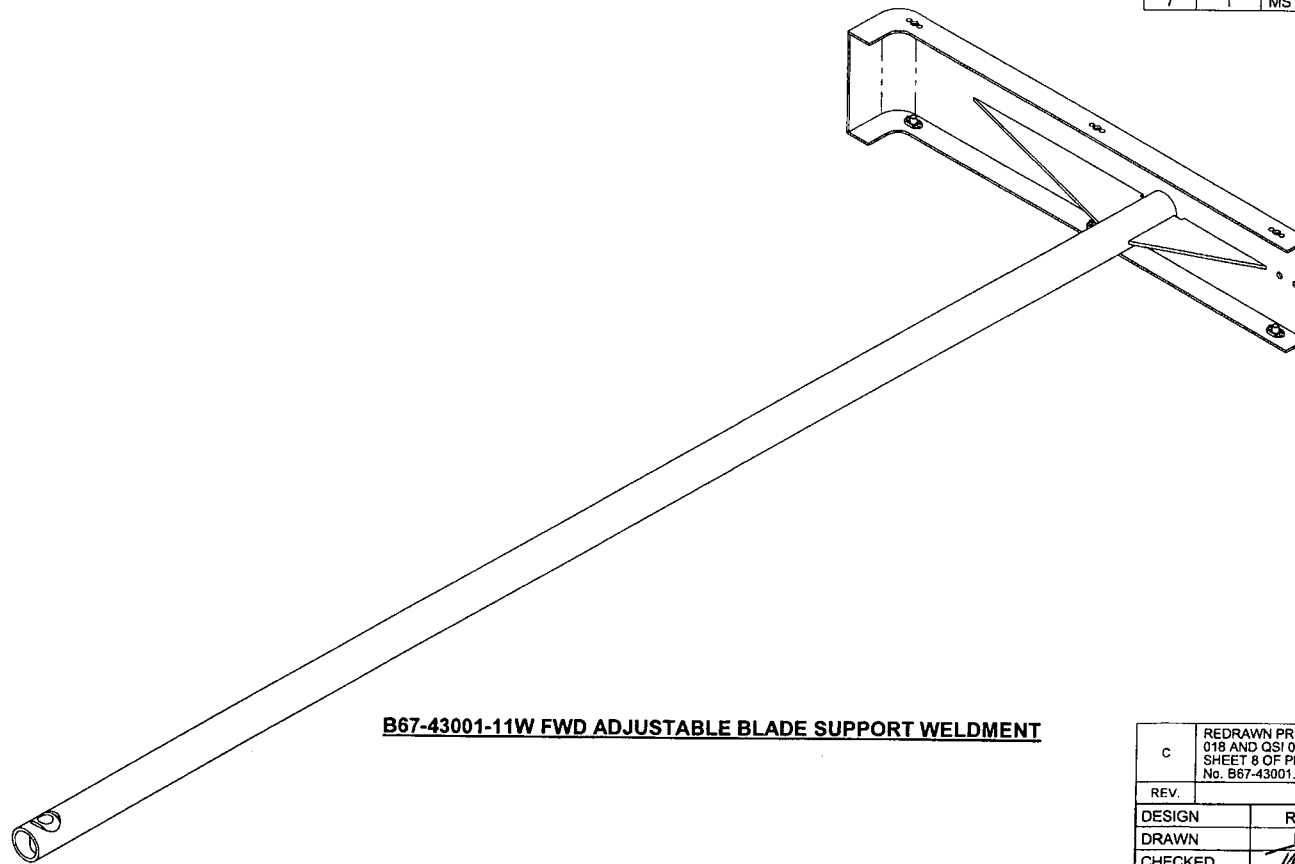
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -11W	P/N	DESCRIPTION
1	X	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-247	INNER TUBE
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-249	INNER TUBE BUSHING
7	1	MS124780	HELICAL INSERT



#8510

RELEASED
2010-09-18

B67-43001-11W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		B67-43001-11W	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		FWD ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.28		

Dart Aerospace Ltd

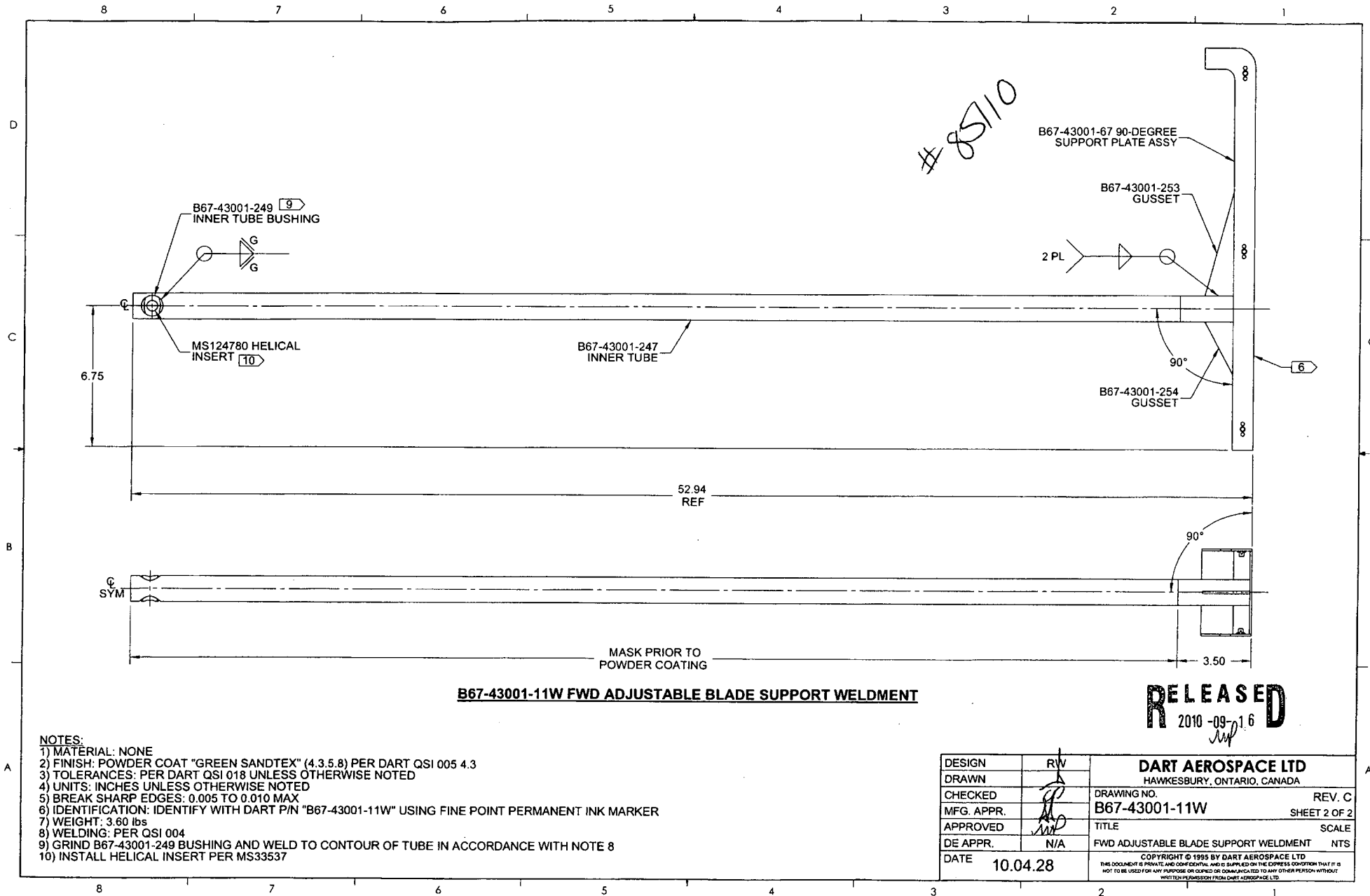
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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

B67-43001-11W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

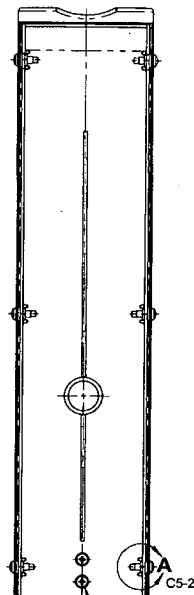
MS27039-1-10 SCREW 8
NAS1149JD0316J WASHER

B67-43001-69 90-DEGREE
COVER PLATE
REF

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-69
90° COVER PLATE ASSEMBLY

B67-43001-11W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT



MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL 8

B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY

B67-43001-83
D-PAD ASSEMBLY, SHORT

RELEASED
2010-09-16
MD

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.83 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\varnothing 0.250$ TO $\varnothing 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-11W AND B67-43001-83 TO B67-43001-69

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-11	SHEET 2 OF 2
APPROVED	AM	TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

7

6

5

4

3

2

1

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